

Work Order ID 128260

Tuesday, January 13, 2015 12:38:51 PM

ASH
128260

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Item ID: 647.7713 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Thread
 Start Date: 1/13/2015 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 1/13/2015 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.7700	A

100 0.00

100

Hardinge CNC LATHE SMALL Memo 0.00

Hardinge CNC Lathe Small

Machine as per folio FB149

FOLIO REV: N/A
 DWG REV: N/A

Deburr

20 φ JFC 2015-01-21

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00

Quality Control

20 φ JFC 2015-01-21

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				20			2/15-1-22
Quality Control									
130	Identify as per dwg & Stock Location: 8 CCK 113	0.00							
130									
Packaging	Memo	0.00				20 X			DAS 26 9-89
Packaging	***COAT PARTS IN OIL BEFORE PUTTING THEM IN A BAG TO PREVENT FROM RUSTING***								JAN 27 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				ML5			1501-23
Quality Control									

15-1-22

Picklist Print

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Work Order ID: 128260

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Parent Item: 647.7713

647 7713

Parent Item Name: Strut Thread

Start Date: 1/13/2015

Required Date: 1/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-11-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.375		Purchased		No			f	10.5830		5			

M4130NR0 375

4130 steel RD bar .375"

Location

Loc Qty

Loc Code

MAT032

10.583

→ 123724

10.583

5 JH 2015-01-21

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04741

SHEET 1 OF 1

DWG NO. 647.7700

REV: NC

PREPARED BY

J. SOTO

DATE: 11/13/2014

EFFECT ON DWG

☒ INC. ☐ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 128260-MCS
1501-13

5	A	647.7714	1	STRUT TUBE	△1	
4	R	647.7713	1	STRUT THREAD	△3	
3	R	647.7712	1	STRUT TUBE	△2	△8
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
		.7703				

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM

CHANGE CATEGORY: ☐ MAJOR ☒ MINOR

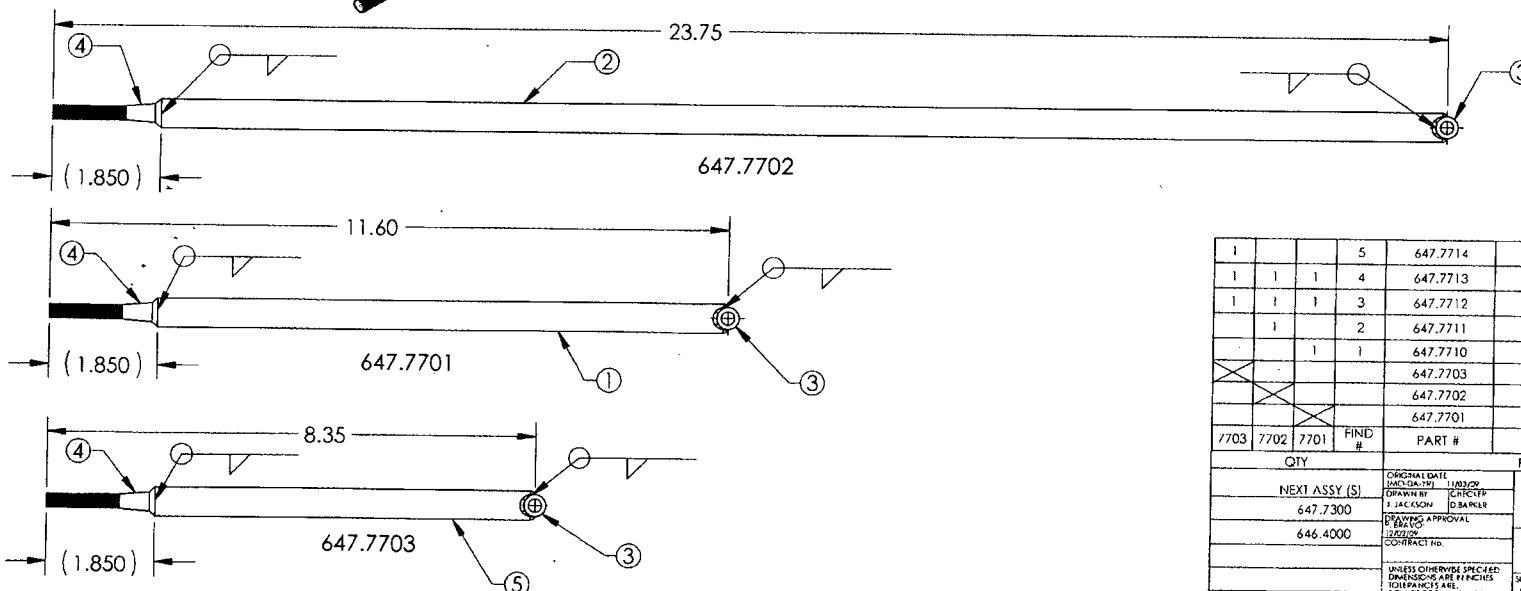
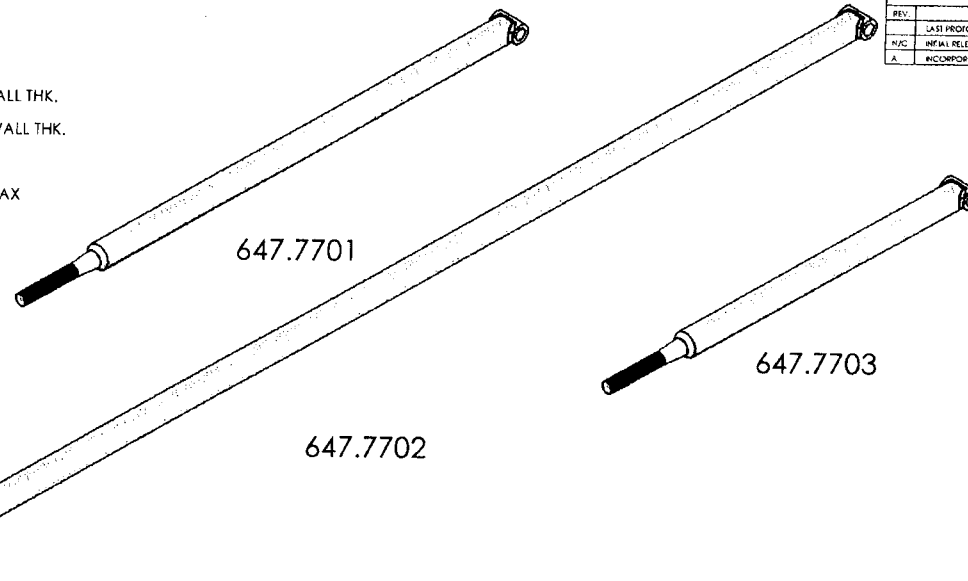
DER REVIEW REQUIRED: ☐ YES ☒ NO

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NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N: 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES
- 6 IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
- 9 MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PP2		R/C
2	INITIAL RELEASE	12/20/09	P. BRAVO
3	INCORPORATED ICH 04741	11/13/14	P. BRAVO



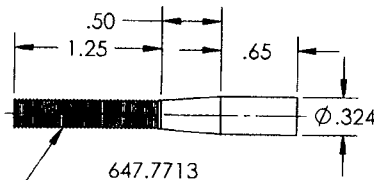
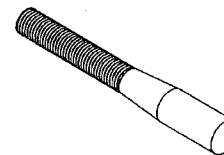
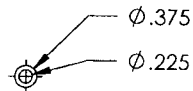
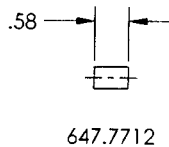
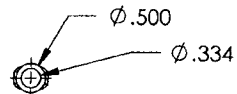
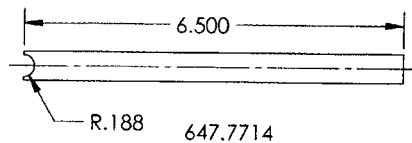
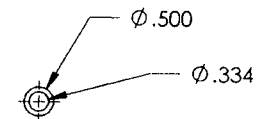
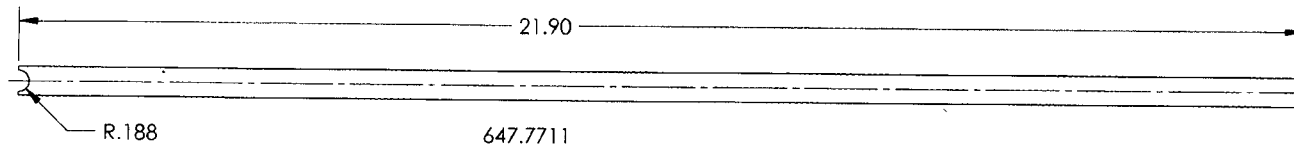
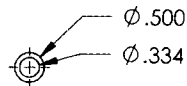
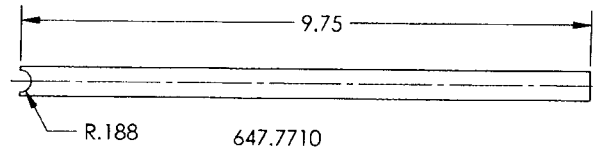
1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.7300				1/10/09			
646.4000				DRAWING APPROVAL			
				1/20/09			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED:			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				1 PLACE DECIMALS ±.01			
				2 PLACE DECIMALS ±.005			
				ANGLES ±.5°			
				SEE CAD CODE			
				DWG. NO. 647.7700			
				SCALE NONE			
				SHEET 1 OF 2			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

STRUT ASSY

REV. A
SCALE NONE
SHEET 1 OF 2

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1/4 - 28 THREAD

ORIGINAL DATE
 MODIFIED DATE
 DRAWN BY: J. JACKSON
 CHECKED BY: J. JACKSON
 DRAWING APPROVAL
 P. BRYAN
 CONTRACT NO.
 UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 3 PLACE DECIMALS ± .01
 ANGLES ± .5°

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760) 724-5300

STRUT ASSY

SHEET	CAGE CODE	DWG. NO.	REV.
B	07M26	647.7700	A
SCALE: NONE			SHEET 2 OF 2

FIRST ARTICLE INSPECTION CHECKLIST

10.04.15